

August 14, 1986

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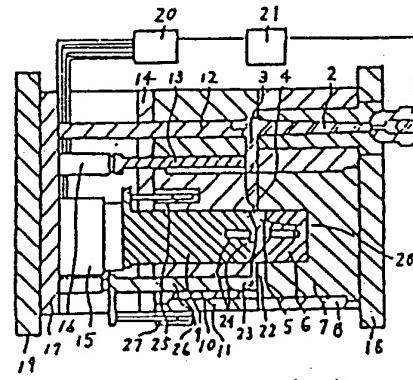
B29C45/56C

(54) MOLD DEVICE FOR INJECTION AND COMPRESSION MOLDING

(11) 61-66623 (A) (43) 5.4.1986 (19) JP
(21) Appl. No. 59-187919 (22) 10.9.1984
(71) HITACHI LTD (72) MASAMICHI TAKESHITA(4)
(51) Int. Cl'. B29C45/26, B29C45/57

PURPOSE: To obtain a concave lense, having no weld line or internal stress and prominent in the accuracies of surface and configuration, by a method wherein an insert is permitted to advance and retreat, a means to detect the thickness of a cavity and a means to effect the microadjustment of a pressure upon supplying resin into cavity are provided and the like.

CONSTITUTION: The movable insert 9 is retreated and a clearance between the movable insert 9 and a fixed insert 6 is set so as to be 2~3 times of lense thickness, thereafter, resin is poured into the clearance. When a supersonic sensor 24 detects that the resin 28 has arrived at the center of the cavity 5, a controller 21 drives a cylinder 16 to cut the resin in a runner apart and, thus, reverse flow is prevented. Subsequently, a pressurizing cylinder 15 is advanced to reduce the volume of the cavity 5 by the movable insert 9 and when a predetermined thickness is detected by a potentiometer 25, pressurizing is stopped and the process is shifted to a cooling process. The position of a balance cylinder 26 is moved in accordance with the contraction of the resin under confirming the position of the balance cylinder 26 by the potentiometer 27, whereby, the resin, whose amount is cope with the amount of contraction, may be supplied into the cavity 5.



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を図ることができる効果がある。

このように、従来技術の欠点を除き、優れた回旋の射出圧縮成形金型装置を提供することができる。

4. 図面の簡単な説明

第1図と第2図は本発明による射出圧縮成形用金型装置の一実施例を示す断面図、第3図は第1図と第2図の断面断面図、第4図は第1図と第2図のキャビティ内に返送して真空吸引装置を及ぼしたことによる他の実施例を示す断面断面図、第5図と第6図は従来の射出圧縮成形用金型装置の一例を示す断面図、第7図は第5図と第6図の断面断面図、第8図(a)は第5図ないし第7図に示す従来の射出圧縮成形用金型装置で充満する際に樹脂がキャビティ内を移動する時の流れを示す説明図、第8図(b)はレンズに形成されたウェルドを示すレンズの正面図である。

5…キャビティ、 6…固定板

9…可動入射、 11…可動板

23…オーバーフローポート、

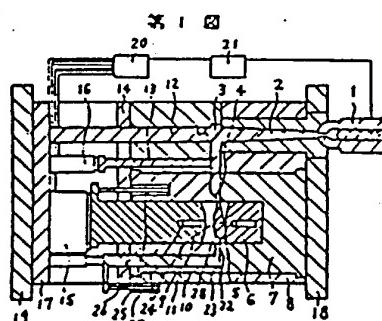
24…温度センサ、

25…ボンシ・メータ、

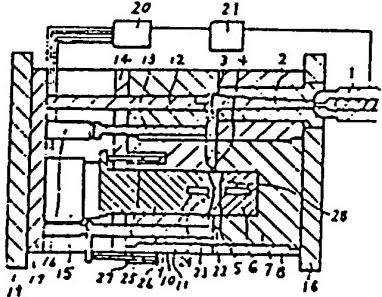
27…ゲートボンシ・メータ。

HITACHI

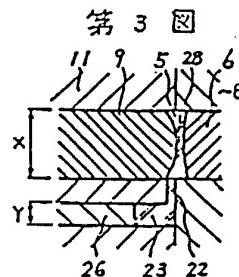
代理人弁理士 高田明



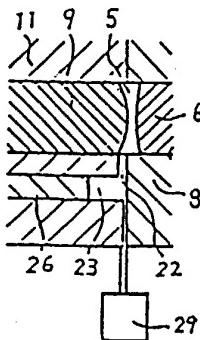
第1図



第2図



第3図

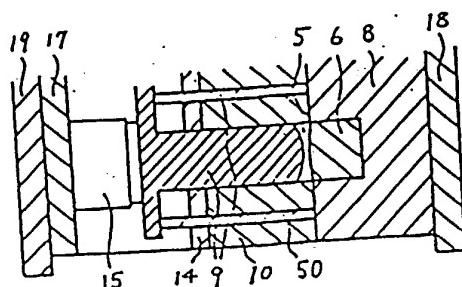
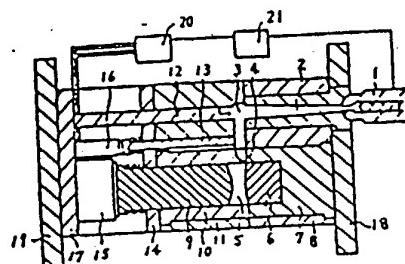


第4図

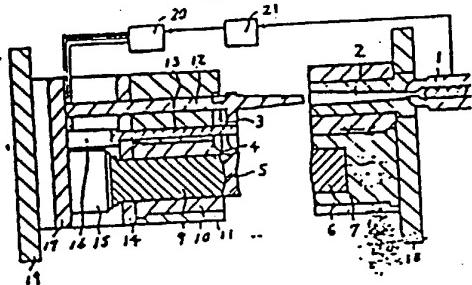
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第7図

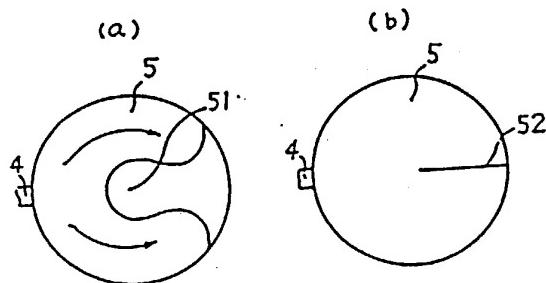
第5図



第6図



第8図



第1頁の続き

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